Date:

6/23/2006 7:34AM

User:

Kim Johnston

PROCESS SHEET

Customer Job No. Estimate No.

P.O. No.

First Issue

Prsht Rev.

This Issue

CU-DAR001 Dart Helicopters Services

27667

10367 NIA

SO No. WIA

MA

27365

Type : MACHINED PARTS 6/23/2006

Drawing Name Part No.

Drawing No. Drawing Rev. Project No. **Material**

Due Date

GUIDE D31121 D3112 REV B

В N/A NIA

6/29/2006

QTY: 8

Prev. Run Written by:

Checked & Approved by:

Comment:

COMMENT BELOW

02.05.22 New Issue

Job Number:



Seg. No. 1.0

Machine or Operation

M6061T6B0625X01500

Description

6061-T6 Bar .625" x 1.5"



Comment:

0.2385 f(s)/Unit Total:

BAND SAW

6061-T6 Bar .625 X 1.500"

Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)

Bar ref DART spec M6061T6B Batch M/4034

SD

2.0

BAND SAW

BAND SAW Comment:

Cut blanks: 0.625" x 1.500 bar x 2.625" long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment:

HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA233

Note: Engrave / scribe DART P/N on part as per dwg.

Deburr break all unmarked sharp edges .005 to 0.010

O6.G6, 23

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



INSPECT PARTS AS THEY COME OFF MACHINE

Comment:

5.0

9.0 ج

Comment: HAND FINISHING1

SECOND CHECK

HAND FINISHING RESOURCE #1

HÁND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06-06-28

Dart Aerospace Ltd

W/O:			WO	RK ORDER	CHANGES					
DATE STEP					Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
		· .								
NCR:			WORK ORDE			CE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Des	cription	Sign 8		cation tion C	Approval Design Mgr	Approval QC Inspector
			Design Mgr	Design	Mgr	Date				
										<u> </u>
i			ı							
Part No		PAR #:	Fault Category	/:	NCR: Y	es (No)	DQA: \$	31	Date: C	16/07/06

QA: N/C Closed: _____ Date: ____

H:\forms\Quality	Assurance\approved	forms\NCRWO re	ev
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NOTE: Date & initial all entries

Job Number:



Seq. No.		hine or Operation	Description		
7.0	POWDER COAT	ING	POWDER COATING		
	Comment:	POWDER COATING	1050) 00100540	7/	01/07/05 (8)
		Powder Coat Grey Sandtex (Ref: 4	INSPECT POWDER COATA	CHEMICAL CON	VERSION
8.0	QC3		INSPECT FOWDER COATA	CHEIVIICAL CON	VERSION
					04 0705 (t)
	Comment:	INSPECT POWDER COAT/CHEM		10	000,03
9.0	PACKAGING 1		PACKAGING RESOURCE #	<u> </u>	
	Comment:	PACKAGING RESOURCE #1 Identify with P/N and B/N using a Location:		nen Stock	3/5(8)
10.0	DC		DOCUMENT CONTROL	/	
					(8)
	Comment:	DOCUMENT CONTROL Inspection Level 21			06/07/06
Job Completion			-	11 Dlo	A.us

Dart Aerospace Ltd

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W/O:		·	V	VORK ORDER CHANGES					
DATE STEP		PROC	PROCEDURE CHANGE			Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
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Non		W	ORK OR	DER NON-CONFORMANC	F (NCF	<u> </u>			
NCR:		•••				· -			· · · · · · · · · · · · · · · · · · ·
DATE	STEP	Description of NC Section A	Initial Design Mgr	Corrective Action Section B Action Description Design Mgr	Sign 8 Date		cation ion C	Approval Design Mgr	Approval QC Inspector
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Part No):	PAR #: F	ault Categ	ory: NCR: Ye	s No	DQA:		Date:	

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
IOTE: Date & initial all entries				QA: N	I/C C	losed:	Date:
f:\forms\Quality Assurance\approved forms\	NCRWO revC		,				

DART AEROSPACE LTD	Work Order:	27667
Description: Guide	Part Number:	D3112-1
Inspection Dwg: D3112 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1,000				
0.500	+/-0.010	.301				
R0.063	+/-0.010	R.063				
0.125	+/-0.010	-126			-	
0.500	+/-0.010	500	-			
0.250	+/-0.010	249				
0.155	+/-0.010	.156				
1.005	+/-0.010	1,005				
0.412	+/-0.010	.410				
0.191	+/-0.010	.183				
2.000	+/-0.010	2.000				
2.500	+/-0.010	2500				
Ø0.191	+0.005/-0.000	0.194				
R0.125	+/-0.010	R.125	1			
	•					
	·					
						

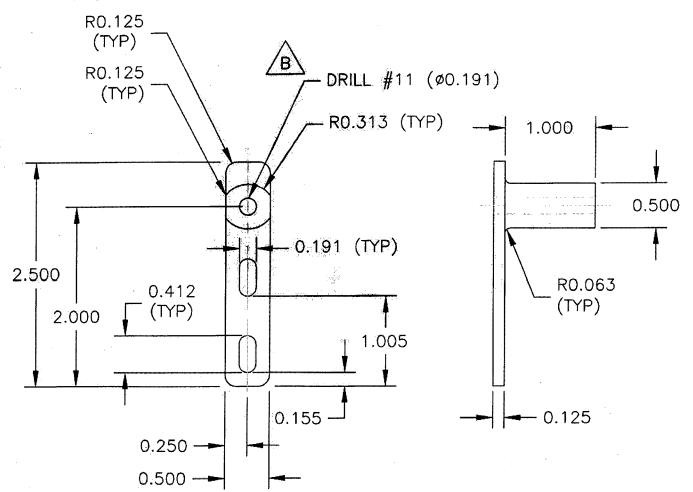
Measured by:	12	Audited by:	86-	Prototype Approval:	N/A
Date:	06.06.23	Date:	06.06.23	Date:	N/A

Rev	Date	Change	Revised by	Approxed
Α	05.07.07	New Issue	KJ/JLM	



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	DESIGN	DRAWN BY	DART	AEROSPACE ESBURY, ONTARIO, CANA	
	CHECKED	APPROVED	DRAWING NO.		REV. B
	A	1-4-	D3112		SHEET 1 OF 1
	DATE		THILE		SCALE
	04.10.18		GUIDE		1:1
Alex.	Δ	02.04.12	NEW ISSUE		

ADD PART MARKING; Ø0.191 WAS Ø0.185 В 04.10.18



D3112-1 GUIDE

NOTES:

1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF. DART SPEC M6061T6B)

SHOP COPY RETURN TO

2) FINISH: CHÉMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 **ENGINEERING**

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TINCONTROLLED COPY SUBJECT TO AMENDMENT

4) ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE

5) BREAK ALL SHARP EDGES 0.005 TO 0.015 6) POSSIBLE SUPPIER: PREMIER P/N B30-23000-17

WORK ORDER

7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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